

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017251**Date Inspected:** 05-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 11AW/11BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SP167-001-052, Side Plate WT stiffener web splice. The welder is identified as #044551 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SP113-001-063, Side Plate WT stiffener web splice. The welder is identified as #069683 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW11B-002, 004, Side Plate transverse splice. The welder is

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identified as #044551 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW11B-003, Bottom Plate transverse splice. The welder is identified as #044551 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 11AE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA081-005, Edge Plate to Side Plate hold back weld. The welder is identified as #052763 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4b-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA082-001, Edge Plate to Side Plate hold back weld. The welder is identified as #047353 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4b-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG066C-024, Longitudinal Diaphragm web to Floor Beam. The welder is identified as #040367 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-TC-U4b-F.

Segment 11BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG068A-078, Edge Plate to Side Plate hold back weld. The welder is identified as #052763 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4b-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA084-005, Edge Plate to Side Plate hold back weld. The welder is identified as #047353 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4b-F.

Segment 10BW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Partial Joint Penetration (PJP) weld joint. The Weld joint is designated as LB003-002-058, Light Bracket to Deck Plate. The welder is identified as #053486 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2332-TC-P4-F.

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This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Partial Joint Penetration (PJP) weld joint. The Weld joint is designated as LB003-002-059, Light Bracket to Edge Plate. The welder is identified as #053486 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2333-TC-P4-F.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as Zhou Peng and Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 10AE/11AE

This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Edge Plate to Side Plate and Edge Plate to Deck Plate hold back CJP welds, cross beam side.

Segment 10CW

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing on the top Counter Weight Connection Plate at panel points 94-95.

Segment 10AW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Bottom Counter Weight Connection Plate at panel points 86-88.

Segment 10BW

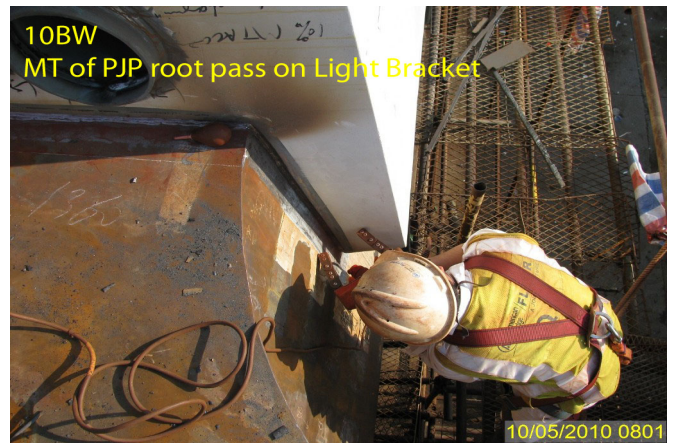
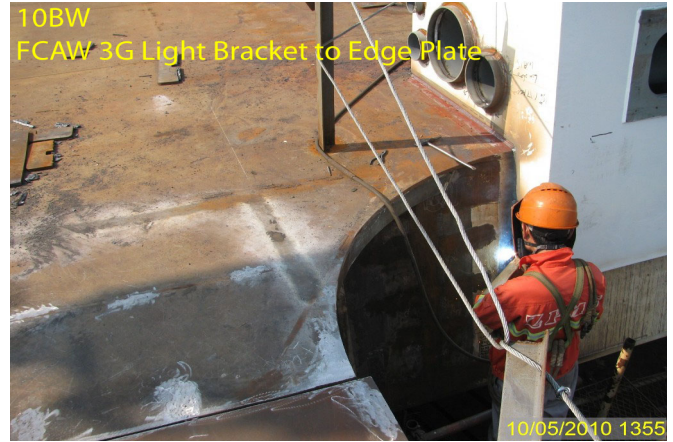
This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the root pass of the Light Bracket to Deck Plate and Edge Plate PJP weld connection.

This QA Inspector observed fit up of the Counter Weight Assembly at panels 90-92.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Dan

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer